

QUALITY ASSURANCE REQUIREMENTS (QAR) (CONTINUATION SHEET)
(QUALITY ASSURANCE PAM 702-101)

PART II - INSPECTION REQUIREMENTS - (CONTD)

TABLE I - CLASSIFICATION OF QUALITY CONFORMANCE CHARACTERISTICS - (CONTD)

<u>CLASS</u>	<u>CHARACTERISTICS</u>	<u>DWG. ZONE</u>	<u>INSPECTION METHOD</u>
<u>MAJOR (CONTD)</u>			
103	VERIFY INTERNAL SPIRAL RETAINING RING IS IN PLACE	C-4	HOLD HOUSING WITH HAND AND PULL AND TURN GEAR. GEAR AND SHAFT MUST NOT COME OUT.
104	VERIFY PUMP ELEMENT ROTATES WHEN SHAFT IS TURNED		ROTATE PUMP SHAFT AND VERIFY PUMP ELEMENT IS ROTATING BY OBSERVATION FROM PUMP PLATE SIDE
105	VERIFY PROPER ORIENTATION OF PORT HOLES IN PLATE ASSEMBLY	C-4	VISUAL
<u>MINOR</u>	<u>A.Q.L. 4.0% DEFECTIVE</u>		
201	IDENTIFICATION MARKINGS (MIL-STD-130)		VISUAL

TABLE II - 100% INSPECTION

1. FUNCTIONAL CHECK: THE TOW PUMP ASSEMBLY IS TO BE MOUNTED TO A FLAT FIXTURE PLATE OR EQUIVALENT WITH SEVEN 1/4-28 UNF-3A X 3.25" GRADE 8 CAPSCREWS AND WASHERS AND TORQUED TO 10-12 FT-LBS. PUMP SHAFT SHOULD ROTATE FREELY AND NOT BIND. EVIDENCE OF BINDING OR NOT TURNING FREELY SHALL BE CAUSE FOR REJECTION. SUCCESSFUL COMPLETION OF TESTS IS REQUIRED BEFORE PUMP ASSEMBLY IS SUBMITTED TO GOVERNMENT FOR ACCEPTANCE.

<u>NUMBER</u>	<u>CHARACTERISTIC</u>	<u>INSPECTION METHOD</u>
106	SHAFT SHOULD ROTATE FREELY AND NOT BIND WHEN PUMP ASSEMBLY IS TORQUED TO FIXTURE PLATE	MANUALLY ROTATE SHAFT

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PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

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